



**UNITED STATES ENVIRONMENTAL PROTECTION AGENCY  
REGION 5  
77 WEST JACKSON BOULEVARD  
CHICAGO, ILLINOIS 60604**

**DATE:** JUL 17 2018  
**SUBJECT:** CLEAN AIR ACT INSPECTION REPORT  
Al-Corn Clean Fuel  
**FROM:** Gregory Gehrig, Environmental Engineer  
AECAB (MI/WI)  
**THRU:** Sarah Marshall, Section Chief  
AECAB (MI/WI)  
**TO:** File

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**BASIC INFORMATION**

**Facility Name:** Al-Corn Clean Fuel

**Facility Location:** 797 5th St., Claremont, MN

**Date of Inspection:** June 29, 2018

**Lead Inspector:** Gregory Gehrig, Environmental Engineer

**Other Attendees:** From Al-Corn Clean Fuel: Randall J. Doyal, C.E.O; J.P. Parenteau, Plant Manager; Thomas Harwood, Owner's Representative; Henry Blair, Safety & Training Compliance Manager.

**Contact Email:** rdoyal@al-corn.com.

**Purpose of Inspection:** CAA Compliance

**Facility Type:** Ethanol production from corn

**Regulations Central to Inspection:** SIP, NSPS and MACT

**Arrival Time:** 0800 hrs

**Departure Time:** 1015 hrs

**Facility Name:** Al-Corn Clean Fuel  
**Facility Location:** 797 5th St., Claremont, MN  
**Date of Inspection:** June 29, 2018

**Inspection Type:**

- ☒ Unannounced Inspection  
☐ Announced Inspection

**OPENING CONFERENCE**

- ☒ Credentials Presented  
☒ CBI warning to facility provided

The following information was obtained verbally from facility personnel.

**Company Ownership:** No recent ownership change.

**Process Description:**

Al-Corn Clean Fuel (Al-Corn) is permitted to produce 130 million gallons per year of ethanol from corn based on their permit issued March 3, 2017, although they are still in the process of expanding their facility to that capacity. They also produce distillers dried grains (DDGS). They have ten fermenters, one beer well and one associated scrubber for pollution control. Al-Corn uses one recuperative thermal oxidizer (TO) and a new regenerative thermal oxidizer (RTO) to control emissions from the mash drying operations conducted to produce DDGS. They load out denatured ethanol via both rail and tank wagon, although mostly by rail.

**TOUR INFORMATION**

**EPA toured the facility:** Yes

**Data Collected and Observations:**

FLIR video was taken of VOC emission points and possible VOC emission points. Al-Corn was operating normally during the facility tour. The following was observed during the tour:

- Control room, where pollution control readings were collected.
- The grain offloading baghouse was at 1.0 inch of water pressure differential.
- Scrubber, which was operating at a pressure differential of 16.9 inches of water, a flow of 145 gallon per minute of water, and additive flow rate of 20 milliliters per minute.
- Fermentors and beer well. No issues noted on newer fermenters. One leaking fabric-type temporary connector on older fermentor #5.
- Older distillation/molecular sieves.
- RTO, which was operating at 1,648 °F.
- TO, which was operating at 1,480 °F.
- Ethanol truck loadout, with leak noted at gasket on vapor return hose.

**Field Measurements:** were not taken during this inspection.

**Facility Name:** Al-Corn Clean Fuel  
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**RECORDS REVIEW**

- Monthly LDAR report conducted June 19, 2018 (taken)
- Facility diagram (taken)

**CLOSING CONFERENCE**


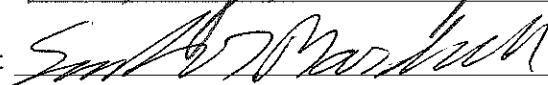
**Requested documents:**

- None

**Compliance Assistance:** EPA indicated that Al-Corn should fully investigate and mitigate uncontrolled venting from the truck loadout and the fermentator #5 fabric-type connector. At the closing conference, Al-Corn personnel indicated they were initiating action to address these concerns.

**Concerns:** None

**SIGNATURES**

Lead Inspector:  Date: 7-17-18  
Section Chief:  Date: 7/17/18

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**APPENDIX A: DIGITAL IMAGE LOG**

<b>1. Inspector Name:</b> Gregory Gehrig	<b>2. Date(s) of Inspection:</b> June 29, 2018
<b>3. Company/Facility Name:</b> Al-Corn Clean Fuel	<b>4. Street Address, City, State:</b> 797 5th St., Claremont, MN
<b>5. Number of Images:</b> 5	<b>6. Archival Record Location:</b> CD-R labeled Al-Corn Images 6.29.2018

<b>Image name</b>	<b>Date and Time (CDT)</b>	<b>Description</b>
MOV_2185	June 29, 2018 at 0837	FLIR video of ethanol loadout operation, including the flare. Leak noted at vapor return line fitting.
MOV_2186	June 29, 2018 at 0840	FLIR video of TO and RTO.
MOV_2187	June 29, 2018 at 0914	FLIR video of scrubber outlet and components atop beer well and newer fermentors.
MOV_2188	June 29, 2018 at 0926	FLIR video of components on older fermenters. Venting from fabric-type connector on Ferm #5.
MOV_2189	June 29, 2018 at 0947	FLIR video of older fermenters.